

Work Order ID 122957

122957

Page 1

Tuesday, July 29, 2014 2:26:52 PM

Item ID: D3589-9

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Fwd Guide Plate

Stop

NS2

Start Date: 7/29/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/29/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: Wm

Date: 7/30/14

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3589	C

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D3589

Prog Rev: C

Dwg Rev: C

Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(8)

2/29/14/09/11

(8)

2/29/14/09/11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework	Scrap	Use-as-is	Skid-tube	Crosstube	Water Jet	Engineering	
NCR No. _____	Suspected	Unapproved		Machining	Small Fab	Prod. Eng. Coor.	Quality	
				Thermoforming	Finishing	Rec/Store/Packaging	Other	
				Large Fab	Composite	Supplier		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge	
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread		
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set		
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration		
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence		

Work Order ID 122957***122957***

Page 2

Tuesday, July 29, 2014 2:26:52 PM

Item ID:	D3589-9	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:				Stop		*NS2*
Item Name:	Fwd Guide Plate					
Start Date:	7/29/14	Start Qty:	4.00	*4*	Cust Item ID:	
Required Date:	7/29/14	Req'd Qty:	4.00	*4*	Customer:	

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check	0.00							DAS 38 9-89
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>WA002</u>	0.00				<u>8</u>			<u>14-8-12</u>
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							<u>14/9/16</u>

(Signature)
14-9-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS						
Part No. _____	Rework	<input type="checkbox"/>	Skid-tube	<input type="checkbox"/>	Crosstube	<input type="checkbox"/>	Water Jet	<input type="checkbox"/>	Engineering	<input type="checkbox"/>
NCR No. _____	Scrap	<input type="checkbox"/>	Machining	<input type="checkbox"/>	Small Fab	<input type="checkbox"/>	Prod. Eng. Coor.	<input type="checkbox"/>	Quality	<input type="checkbox"/>
	Use-as-is	<input type="checkbox"/>	Thermoforming	<input type="checkbox"/>	Finishing	<input type="checkbox"/>	Rec/Store/Packaging	<input type="checkbox"/>	Other	<input type="checkbox"/>
	Suspected Unapproved	<input type="checkbox"/>	Large Fab	<input type="checkbox"/>	Composite	<input type="checkbox"/>	Supplier	<input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
	Bending	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>
	Centre Not Concentric	<input type="checkbox"/>	Grain	<input type="checkbox"/>
	Cracks	<input type="checkbox"/>	Hardware	<input type="checkbox"/>
	Crimp/Kink/Ripple/Wave	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>
	Cuffs	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>
	Crushing	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>
	Heat Treat	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>
	Inspection Strip in Tube	<input type="checkbox"/>	Misread	<input type="checkbox"/>
	Marks/Chatter	<input type="checkbox"/>	Off-set	<input type="checkbox"/>
	Turning Sequence	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>
	Wave/Twist in Tube	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>

Picklist Print

Page 1

Tuesday, July 29, 2014 2:26:52 PM

Work Order ID: 122957

122957
D3589-9

Parent Item: D3589-9

Parent Item Name: Fwd Guide Plate

Start Date: 7/29/14

Required Date: 7/29/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-06-05 new issue DD verified by:ec
09-02-20 rev.b as per dwg DD verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	608.0570	0.06	0.252632			

M304S16GA

304/316 Sheet .063

**

De 14/09/14

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	363.057	
M127821	71.317	
(M129102)	14.54	
M129449	277.2	
TPI	245	
M129545	245	

80

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____
 Part No. _____
 NCR No. _____

DISPOSITION

Rework
 Scrap
 Use-as-is
 Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge	
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread		
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set		
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration		
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence		

DART AEROSPACE LTD	Work Order:	626957
Description: 3589 Fwd Guide plate	Part Number:	3589-9
Inspection Dwg: 3589	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

38

30
B-80

Measured by:	De/12	Audited by:	9-89	Preliminary Approval:	
Date:	14/09/11	Date:	14-9-12	Date:	
Rev	Date	Change		Revised by	Approved

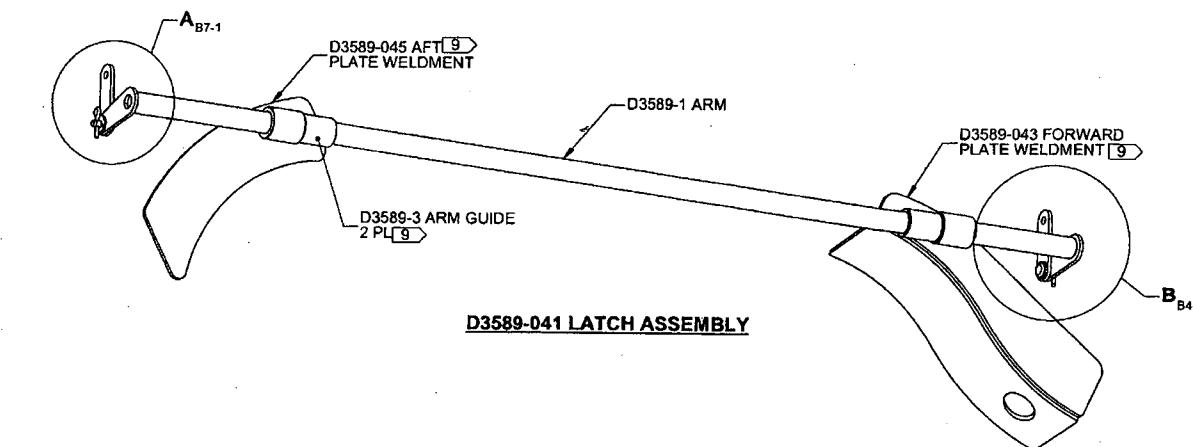
10.04.15

ITEM	QTY. -041	P/N	DESCRIPTION
X	1	D3589-041	LATCH ASSEMBLY
1	1	D3589-043	FORWARD PLATE WELDMENT
2	1	D3589-045	AFT PLATE WELDMENT
3	1	D3589-1	ARM
4	2	D3589-3	ARM GUIDE
5	2	D3589-13	LUG
6	2	D3589-15	LINK
7	4	AN960JD4	WASHER
8	2	MS20392-1C7	PIN
9	2	MS24665-1010	COTTER PIN

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 125957
7/30/14 Wm

RELEASED
2012-07-16
Wm



D3589-041 LATCH ASSEMBLY



DETAIL A: LINK ASSEMBLY DETAIL D8-1

SCALE 2X
2 PL

DETAIL B: WELDING AND
LINK ASSEMBLY DETAIL C3-1

SCALE 2X
2 PL

D3589-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.75 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
- 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

C	REVISED D3589-5-275 WAS 2.00 (ZN B2-1) ADDED D3589-21 (ZN B3-4). AFFECTS D3589-042 (ZN A7-3) AND D3589-048 (ZN A3-3). REVISED D3589-15: Ø0.140 WAS Ø0.129 (ZN B4-7). Ø0.00 WAS 1.150 (ZN C4-7) ADDED D3589-23 (ZN C3-4). AFFECTS D3589-043-045 (ZN D7-2) AND D2-2 REASON: PART12-177	MB	12.07.04
B	0.90 AND 0.63 REF WERE 1.07 AND 0.60 (ZN C6-2). 0.50, 2.00 WAS 1.50 (ZN B2-2). 19.00 WAS 18.88 (ZN D4-4). 1.00 WAS 0.90 (ZN C3-3) AND D3589-11F (ZN C2-3) REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION	MB	08.06.25
A	NEW ISSUE	MB	08.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>A</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>A</u>	DRAWING NO. REV. C D3589	
CHECKED	<u>A</u>	SHEET 1 OF 8	
MFG. APPR.	<u>A</u>	TITLE SCALE LATCH ASSEMBLY NTS	
APPROVED	<u>A</u>	DATE 12.07.04	
DE APPR.	<u>A</u>	COPYRIGHT © 2008 BY DART AEROSPACE LTD ALL RIGHTS RESERVED. THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8

7

6

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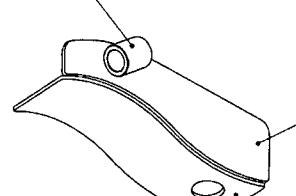
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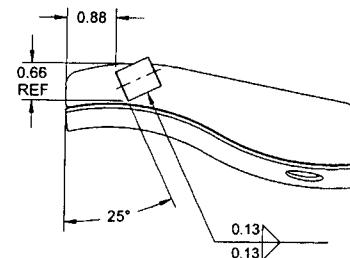
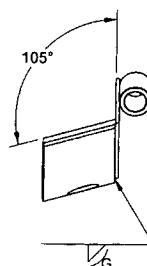
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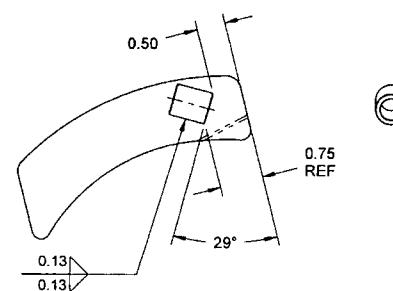
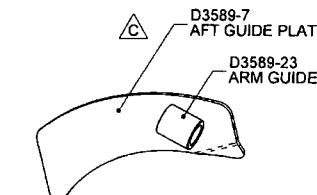
D3589-23
ARM GUIDE

D3589-9
FORWARD GUIDE PLATE
D3589-11 [9]
FORWARD GUIDE PLATE



D3589-043 FORWARD PLATE WELDMENT

ITEM	QTY -043	QTY -045	P/N	DESCRIPTION
X			D3589-043	FORWARD PLATE WELDMENT
	X		D3589-045	AFT PLATE WELDMENT
1	1		D3589-7	AFT GUIDE PLATE
2	1		D3589-9	FORWARD GUIDE PLATE
3	1		D3589-11	FORWARD GUIDE PLATE
4	1	1	D3589-23	ARM GUIDE



D3589-045 AFT PLATE WELDMENT

RELEASED
2012-07-16
11

D3589-043/-045 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
 - D3589-043 = 0.23 lbs
 - D3589-045 = 0.10 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

8

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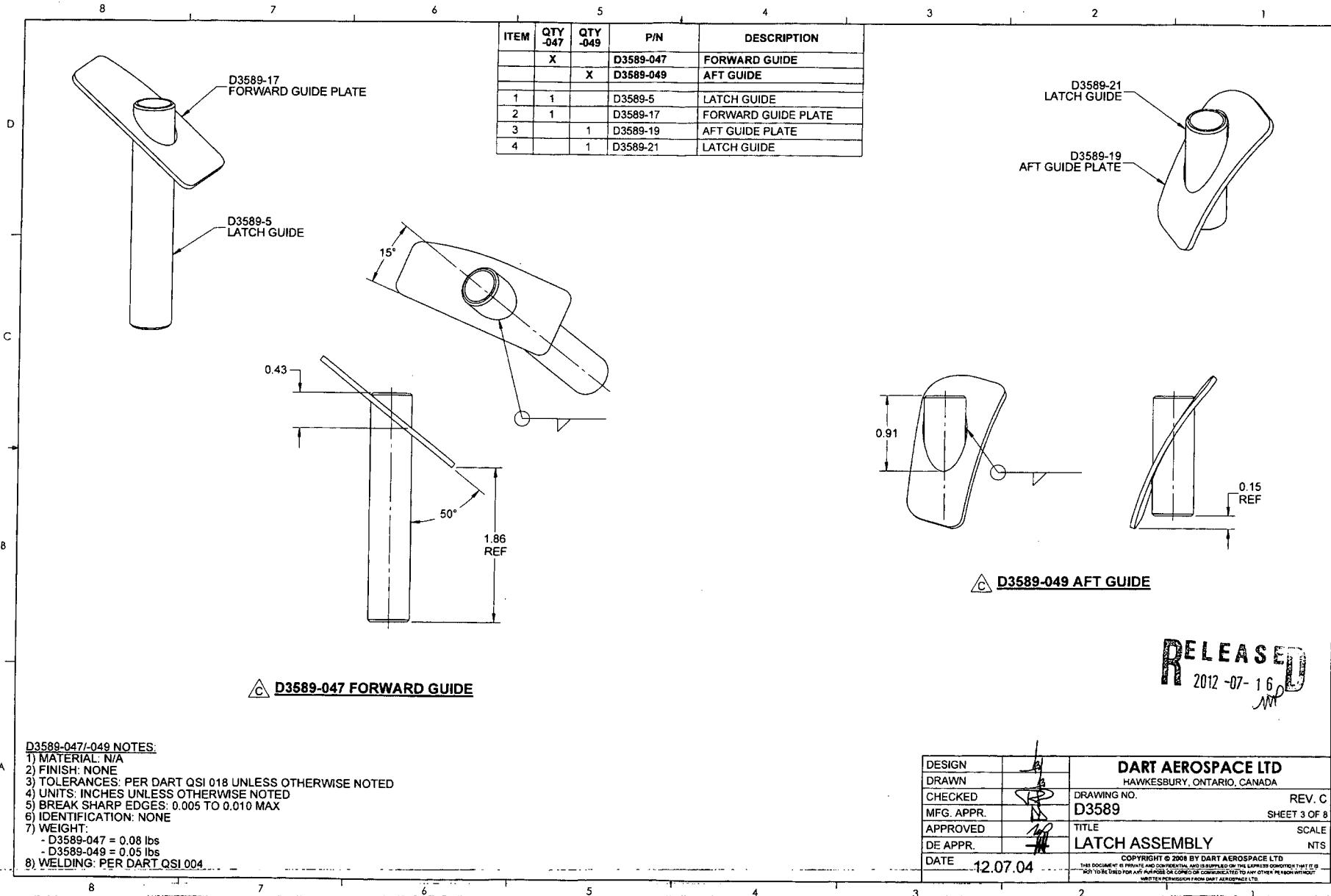
3

2

1

DESIGN	<i>1</i>	DART AEROSPACE LTD	
DRAWN	<i>1</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RP</i>	DRAWING NO. D3589	
MFG. APPR.	<i>DA</i>	REV. C	
APPROVED	<i>10</i>	SHEET 2 OF 8	
DE APPR.	<i>10</i>	TITLE LATCH ASSEMBLY	
DATE	12.07.04	SCALE	NTS

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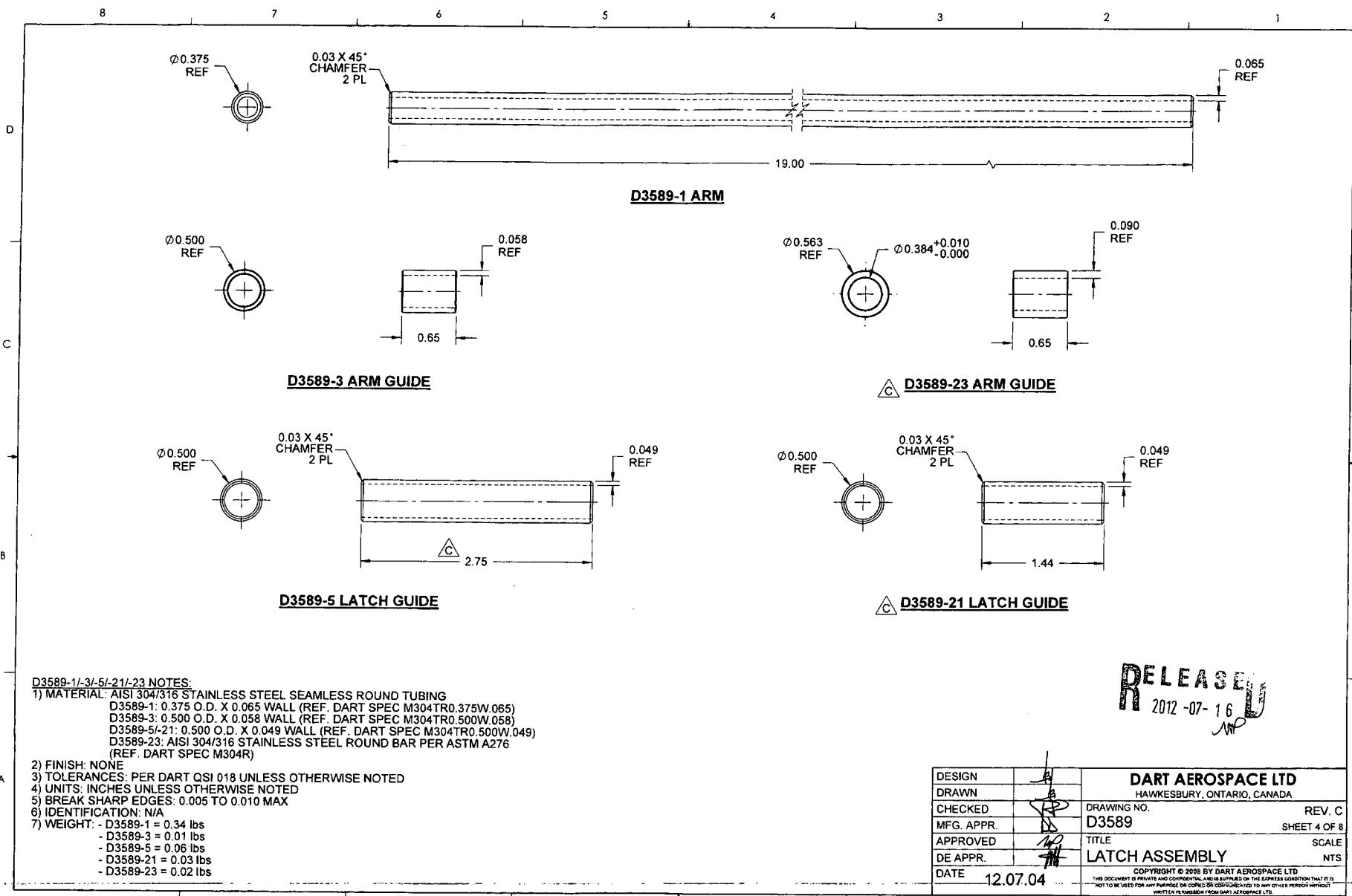
D3589-047/049 NOTES:

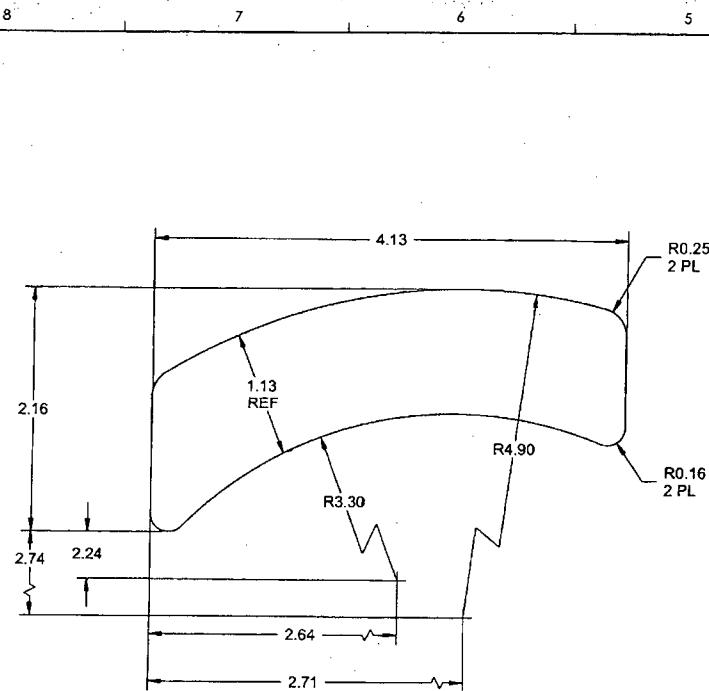
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
 - D3589-047 = 0.08 lbs
 - D3589-049 = 0.05 lbs
- 8) WELDING: PER DART QSI 004.

DESIGN	<i>b1</i>	DART AEROSPACE LTD	
DRAWN	<i>b3</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RP</i>	REV. C	
MFG. APPR.	<i>N</i>	D3589	
APPROVED	<i>100</i>	SHEET 3 OF 8	
DE APPR.	<i>100</i>	TITLE	
DATE	12.07.04	SCALE	
		NTS	

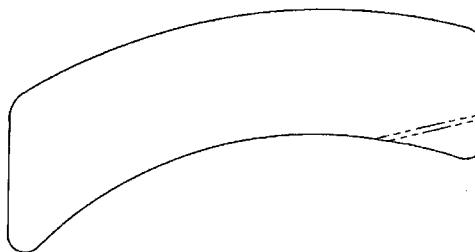
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RELEASED
2012-07-16
NP





D3589-7F AFT GUIDE PLATE
FLAT PATTERN



D3589-7 AFT GUIDE PLATE
MAKE FROM D3589-7F

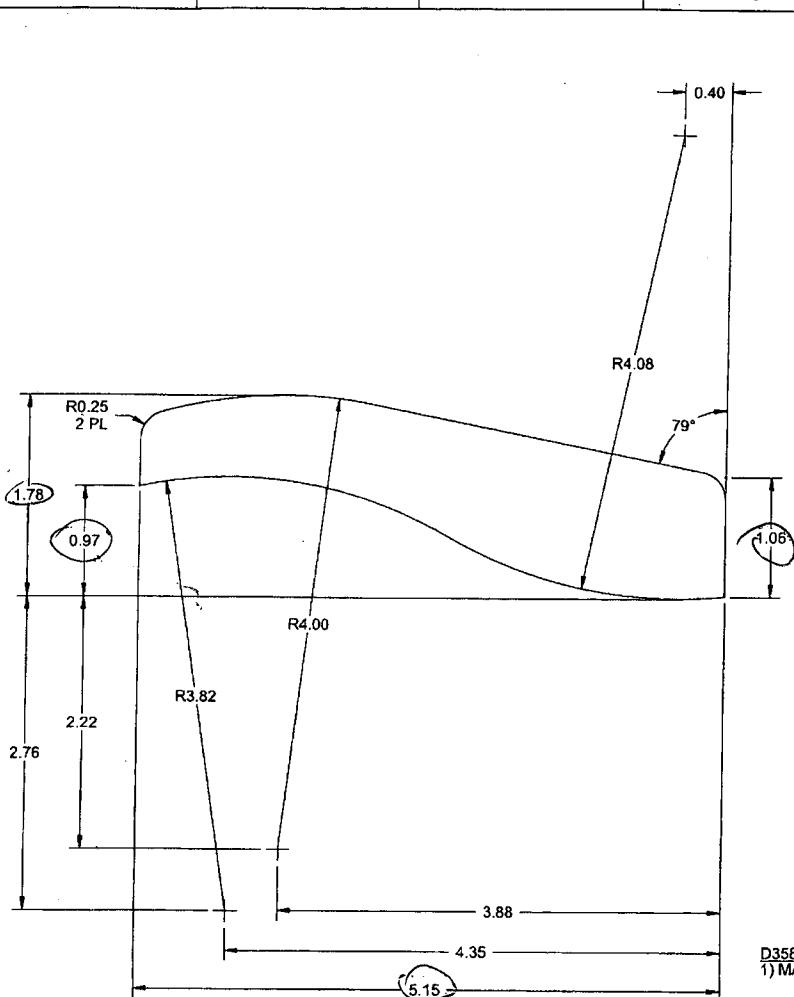
RELEASED
2012-07-16
NP

A D3589-7/-7F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH, 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

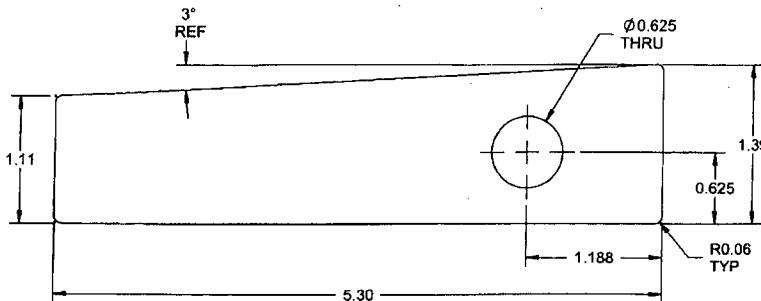
DESIGN	<i>1</i>	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>2</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>3</i>	D3589	SHEET 5 OF 8
APPROVED	<i>4</i>	TITLE	SCALE
DE APPR.	<i>5</i>	LATCH ASSEMBLY	
DATE	12.07.04	NTS	

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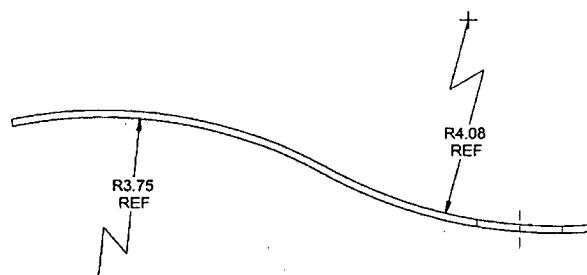


D3589-9 FORWARD GUIDE PLATE

D3589-9-11/-11F NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET,
 PER AMS 5513 OR AMS 5524,
 OR MIL-S-5059 (ANNEALED) 2B FINISH
 16 GAUGE (0.063 THICK),
 (REF. DART SPEC M304516GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS
 OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.09 lb. EACH
 8) CONTROL SHAPE PER DT9021 TEMPLATE



D3589-11F FORWARD GUIDE PLATE
FLAT PATTERN



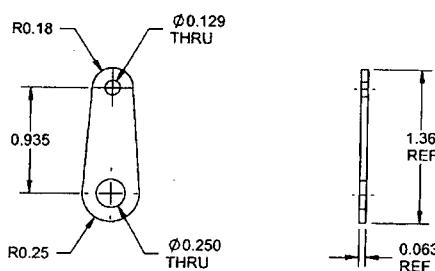
D3589-11 FORWARD GUIDE PLATE
 (MAKE FROM D3589-11F)

RELEASED
 2012-07-16

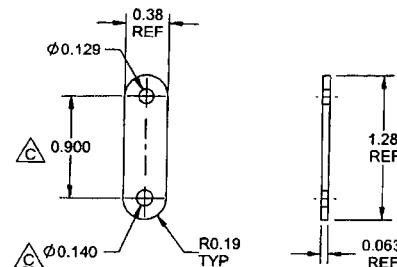
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.		REV. C
APPROVED	<i>[Signature]</i>	D3589
DE APPR.		SHEET 6 OF 8
DATE	12.07.04.	TITLE
		SCALE
		NTS
		LATCH ASSEMBLY

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8 7 6 5 4 3 2 1



D3589-13 LUG



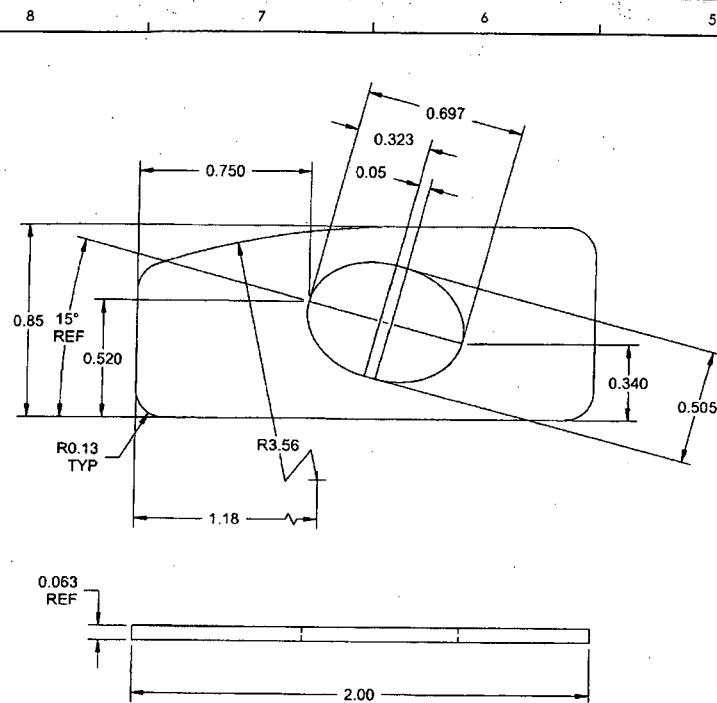
D3589-15 LINK

RELEASED
2012-07-16
100

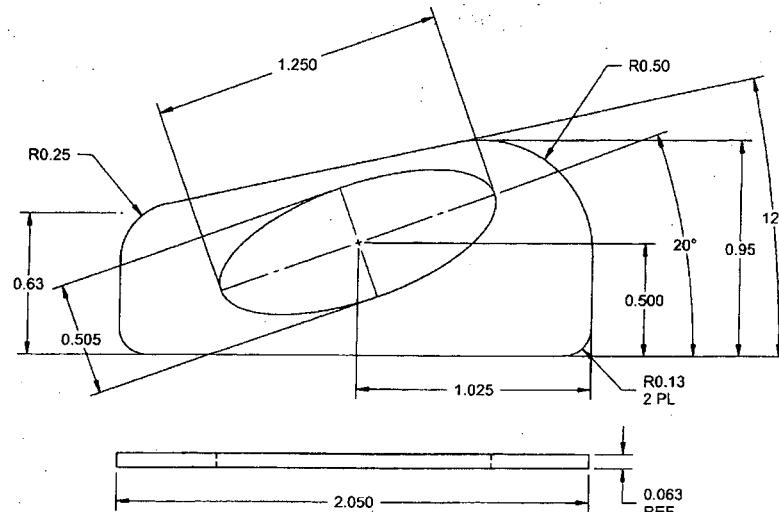
D3589-13/15 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH, 16 GAUGE (.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs EACH

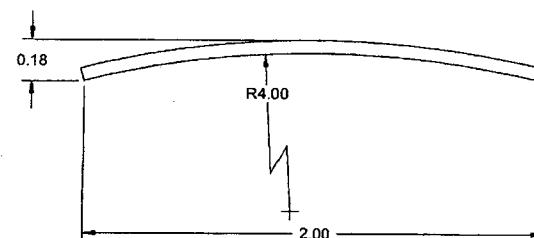
DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3589 SHEET 7 OF 8
APPROVED		TITLE SCALE
DE APPR.		LATCH ASSEMBLY NTS
DATE	12.07.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



D3589-17 FORWARD GUIDE PLATE



D3589-19F AFT GUIDE PLATE FLAT PATTERN



D3589-19 AFT GUIDE PLATE
(MAKE FROM D3589-19F)

RELEASED
2012-07-16

D3589-17-19F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs EACH

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		
MFG. APPR.		REV. C
APPROVED		SHEET 8 OF 8
DE APPR.		TITLE
DATE	12.07.04	SCALE
		NTS

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